

Work Order ID 53956

January 28, 2010 11:22:47 AM

Page 1

Item ID: D4015-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearbar Weldment

Start Date: 11/23/09 Start Qty: 60.00

Cust Item ID:

Required Date: 11/30/09 Req'd Qty: 60.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4015

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 10-1-28

110

Weld per dwg A/R Hardcoat S.S. Batch: M113571

0.00



Large Fab

Memo

0.00

Large Fab

EL 10-1-28 (X93)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S. Solodas

count
(X23)

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ Siobels

(493)

QC

Memo

0.00

Quality Control

135

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

11105642

Powdercoat

Memo

0.00

⇒ 10-01-29

(493)

Powder Coating

POWDER COAT:

Start Time: 10:00AM

Oven Temperature: 320°F

Finish Time: 10:30AM

136

QC3- Inspect Part Finish

0.00

OK 10-01-29

(493)

QC

Memo

0.00

Quality Control

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location: ST110

0.00



Packaging

Memo

0.00

Packaging

P 11/21/09 (93)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03

mk

10-12-2

Picklist Print

January 28, 2010 11:22:47 AM

Page 1

Work Order ID: 53956



Parent Item: D4015-041



Parent Item Name: Wearbar Weldment

Start Date: 11/23/09

Required Date: 11/30/09

Comments: IPP RevA: New issue 09.11.03 DD verified by:EC
remove waterjet 09.11.03 DD verified by:EC
dwg 09.11.18 DD verified by:JLM

IPP RevB:
IPP RevC: revB as per

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D4015-1		Manufactured	No			100	Each	93.0000	60.0000			
Wearbar												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53959

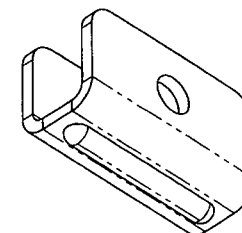
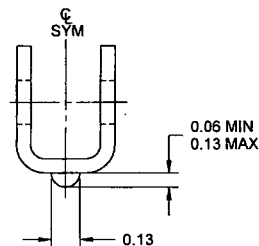
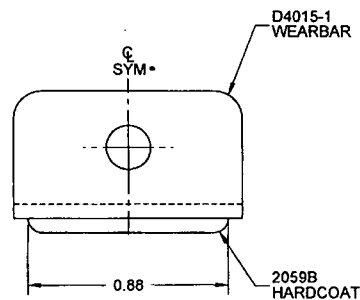
93

93

93

10-1-28

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



D4015-041 WEARBAR WELDMENT

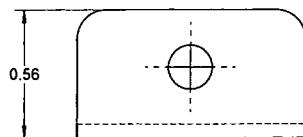
RELEASED
2009-11-24

NOTES:

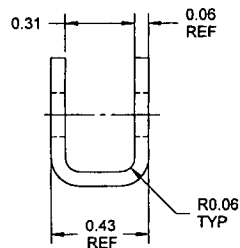
- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 **B**
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

B	CHANGED COLOR TO BLACK SANDEX	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.11.13		

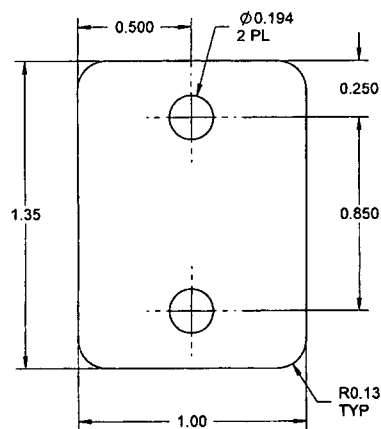
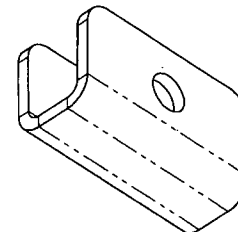
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4015	REV. B
TITLE WEARBAR WELDMENT	SCALE NTS
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D4015-1 WEARBAR
MAKE FROM D4015-1



*no
53956*



D4015-1F WEARBAR FLAT PATTERN

RELEASED
2009-11-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D4015	SHEET 2 OF 2
APPROVED	<i>HP</i>	TITLE	SCALE
DE APPR.	<i>HP</i>	WEARBAR WELDMENT	NTS
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